STABILO BOSS
REVERSE
FORWARD
0 1 2 3
Mahr
Millimess
0,001mm
12 : 30
13 : 27.6923
TO DO TURNING MANDREL FOR
CUT DOWN LAST 15 2N MORE
DO THE 2N 13 GEARS OR NOT
AND LOOSE
THEN DO
ON AFTERWARDS ON LATHE.
13 2N 15 OD
1 . 27.69230
2 55.3846153
3 83.0769230
4 110.7692307
5 138.4615384
6 166.1538461
7 193.8461538
8 221.5384615
9 249.2307692
10 276.9230769
11 304.6153846
12 332.307692
13 360
60 30
41.5 20.72 22 21
23.07 11.54 55 12
4.61 2.3 83 2
46.15 23.07 110 23
27.7 13.8 138 14
9.23 4.61 166 5
50.72 25.38 193 25
32.30 16.15 221 16
13.85 6.92 249 7
55.38 27.69 276 28
36.92 18.46 304 18
18.46 9.23 332 9
THIS IS THE METHOD FOR THE FRACTIONS
DIFF 1:28 - 12
ALL POSSIBLE

(0.691667 BETTER) (0.69167 = 41.5)

41.5 x 13 = 539.5 ÷ 60 = 8.99

SO ITS [41.5 OF 60] OR [20.75]

12 = 30

13 = 27.6923 → 0.7 x 60 = 42 → 0.683 = 41 → 27.691 x 13 = 359.9

→ 25.7167 x 14 = 360.033 43 OF 60 21.5 OF 30

14 : 25.7142857

15 = 24

16 = 22.5

17 = 21.17647

18 = 20

19 = 18.947368

20 = 18

21 : 17.1428571

11 OF 30

22 : 16.363636 → 16.367 x 22 = 360.074 → 0.367 x 60 = 22 OF 60

23 : 15.6521739 → 15.65 x 23 = 359.95 = [39 OF 60] OR 19.5

24 = 15

25 = ~~15~~ 14.4

26 = 13.8461538

27 = 13.3333

28 = 12.8571 → 12.85835 x 28 = 360.033

SO FOR A 40 COMBO

DIFFICULT * 13 - 27 *13.3333

15 - 25 * 14.4

22.5 * 16 - 24

20 - 20

24 - 16 * 22.5

14.4 * 25 - 15

13.3333 * 27 - 13 * DIFFICULT?

DIFFICULT * : 28 - 12
ALSO POSSIBLE

TO DO TOMORROW

CUT DOWN MANDREL FOR 15ZN 17MM OD

DO THE LAST 15 ZN MODULE 1 GEARS THAT ARE LOOSE

THEN DO ZN 13 GEARS ON ROD.
CUT AFTERWARDS ON LATHE

SCALE
ROTARY TABLE
CLOSEST
LINE

13 ZN 15 OD

		60	30	DEG	MIN
1	27.69230	41.5	20.72	27	21
2	55.3846153	23.07	11.54	55	12
3	83.07692307	4.61	2.3	83	2
4	110.7692307	46.15	23.07	110	23
5	138.46153846	27.7	13.8	138	14
6	166.1538461	9.23	4.61	166	5
7	193.8461538	50.77	25.38	193	25
8	221.5384615	32.30	16.15	221	16
9	249.23076923	13.85	6.92	249	7
10	276.9230769	55.38	27.69	276	28
11	304.6153846	36.92	18.46	304	18
12	332.307692	18.46	9.23	332	9
13	360				

THIS IS THE METHOD FOR THE UNREASONABLE AND IRRATIONAL FRACTIONS